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मानक

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IS 7511-3 (1986): Dimensions For Neck Finishes, Part 3:
Roll-on thread non-pilfer-proof (RONPP) [CHD 10: Glassware]



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“Knowledge is such a treasure which cannot be stolen”

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*Indian Standard*

DIMENSIONS FOR NECK FINISHES
PART 3 ROLL-ON THREAD NON-PILFERPROOF (RONPP)
(First Revision)

1. Scope — Specifies dimensions for roll-on threads non-pilferproof (RONPP).

2. Dimensions

2.1 The dimensions of the roll-on thread non-pilferproof shall be as given in Table 1.

2.2 Sealing Surfaces — The sealing surface may be flat or radiused and shall conform to the dimensions given in Table 1. The surface shall be as regular and smooth as possible.

3. Checking and Inspection

3.1 All essential dimensions may be ascertained by any appropriate method of measurement. The procedure of gauging and the gauges employed may be the same as detailed in Fig. 1 of IS : 7511 (Part 1)-1986 'Dimensions for neck finishes : Part 1 Shallow continuous thread finish (first revision)'.

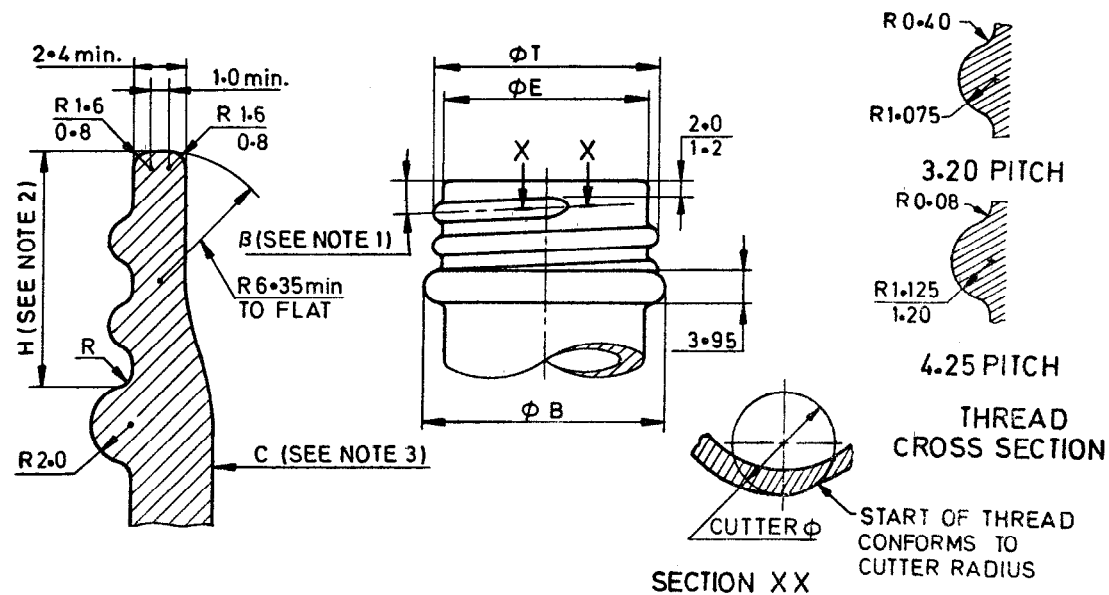
Adopted 18 February 1986

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TABLE 1 DIMENSIONS FOR ROLL-ON THREAD NON-PILFERPROOF (RONPP)
(Clauses 2.1 and 2.2)

All dimensions in millimetres.



No. or Size	<i>T</i>		<i>E</i>		<i>B</i>		<i>H</i>		<i>C</i>	<i>R</i>	Angle β	Thread Cutter Dia	Pitch
	<i>Max</i>	<i>Min</i>	<i>Max</i>	<i>Min</i>	<i>Max</i>	<i>Min</i>	<i>Max</i>	<i>Min</i>	<i>Min</i>	<i>Max</i>			
18	17'90	17'40	15'75	15'25	19'60	19'10	8'85	8'45	8'30	0'40	3°30'	9'50	3'20
20	19'90	19'40	17'80	17'30	21'60	21'10	8'85	8'45	10'30	0'40	3°07'	9'50	3'20
22	21'60	21'10	19'50	19'00	23'30	22'80	8'85	8'45	12'00	0'40	2°51'	9'50	3'20
24	23'90	23'40	21'70	21'20	25'55	25'05	8'85	8'45	13'10	0'40	2°34'	9'50	3'20
25	24'80	24'30	22'40	21'90	26'60	26'10	11'15	10'65	13'70	0'80	3°18'	12'70	4'25
28	27'60	27'00	25'25	24'60	29'40	28'80	11'15	10'65	15'60	0'80	2°57'	12'70	4'25
31·5	30'60	30'00	29'20	28'60	32'40	31'80	11'15	10'65	18'60	0'80	2°38'	12'70	4'25
33	32'10	31'50	29'74	29'10	33'90	33'30	11'15	10'65	20'10	0'80	2°31'	12'70	4'25
35	34'60	33'90	32'30	31'50	36'45	35'70	11'15	10'65	22'20	0'80	2°20'	12'70	4'25
38	37'50	36'70	35'10	34'30	39'30	38'50	11'15	10'65	25'10	0'80	2°09'	12'70	4'25
43	42'00	41'25	39'60	38'85	43'80	43'10	11'15	10'65	29'60	0'80	1°55'	12'70	4'25
45	44'20	43'30	41'80	40'91	46'00	45'10	11'15	10'65	31'90	0'80	1°49'	12'70	4'25
48	47'50	46'60	45'10	44'20	49'30	48'40	11'15	10'65	35'10	0'80	1°41'	12'70	4'25
53	52'50	51'60	50'10	49'20	54'30	53'40	11'15	10'65	40'10	0'80	1°31'	12'70	4'25
58	56'50	55'50	54'10	53'10	58'30	57'30	11'15	10'65	44'10	0'80	1°25'	12'70	4'25
63	62'50	61'50	60'10	59'10	64'30	63'30	11'15	10'65	50'10	0'80	1°16'	12'70	4'25
70	69'50	68'50	67'10	66'10	71'30	70'30	11'15	10'65	57'10	0'80	1°08'	12'70	4'25

Notes 1 — β = Helix angle or angle of fixture to cutter; and $\tan \beta = \frac{\text{Pitch}}{\pi(\text{Mean between mean } T \text{ and mean } E)}$

2 — *H* dimension represents distance from top of finish down to point where line tangent to *T* intersects the top of locking ring.

3 — *C* dimension is intended for filling tube clearance and should be confirmed with the glass manufacturer.

4 — The *Max* and *Min* of *T* and *E* may be determined by the use of suitable gauges.

EXPLANATORY NOTE

A variety of glass finishes are now being produced by the glass containers industry. Most of these finishes are being used by packers who have facilities for high speed filling and capping operations. Consequently it has become necessary to standardize upon the dimensions of different types of glass finishes.

This standard was first issued in 1974 titled 'Summary sheet on glass containers neck finishes'. As the standard mainly lays down the dimensions for various types of neck finishes for glass containers, the standard has been retitled as 'Dimensions for neck finishes'. Since its first issue, it was observed that a number of sizes recommended under the shallow continuous thread finish range were not in use. On the contrary, a number of sizes, not included in earlier issue were very popular with the industry. Also glass neck finishes not included in the first version were popular with the trade. In view of this, the revision of the standard became necessary.

The following are some of the changes made in this revision:

- a) The sizes of various neck finishes not in use were deleted and the additional sizes included.
- b) A new glass finish range namely, shallow continuous deep thread finish, has been included.
- c) Certain individual dimensions of glass neck finishes have been revised in view of the limitations posed by the glass container manufacturing processes.
- d) Vacuum lug finishes which have recently become very popular with wide mouth glass containers have also been included. These finishes are non-pilferproof.
- e) The notations representing different glass finish dimensions have been changed to be in conformity with internationally accepted practices.
- f) Tall continuous neck finish has been deleted as the same is no longer popular.

This standard is being issued in the following parts:

Part 1 Shallow continuous thread finish (R3);

Part 2 Shallow continuous thread finish for deep screw caps (R3/D);

Part 3 Roll-on threads non-pilferproof (RONPP);

Part 4 Roll-on threads pilferproof (ROSPP);

Part 5 Vial goldie seal glass finishes;

Part 6 Dual neck finish;

Part 7 Crown finish; and

Part 8 Vacuum lug finish.

While preparing this standard, assistance has been derived from the following:

ISO 8162-1985 Glass containers — Tall crown finishes — Dimensions, issued by International Organization for Standardization (ISO);

ISO 8163-1985 Glass containers — Shallow crown finishes — Dimensions, issued by International Organization for Standardization (ISO);

ISO/DP 9100 Glass containers — Vacuum lug finishes for wide mouth container — Dimensions, issued by International Organization for Standardization (ISO);

BS 1918 : Part 1-1978 Glass container finishes: Part 1 Specification for continuous thread finish, issued by British Standards Institution (BSI); and

BS 1918 : Part 2-1981 Glass container finishes: Part 2 Specification for crown finish, issued by British Standards Institution (BSI).